

Work Order ID 75827

75827

Page 1

Monday, October 31, 2011 3:38:25 PM

Item ID: D3484-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tail Light Fairing Assembly, LH
 Start Date: 11/1/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 11/22/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 11-10-31 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3484	Rev F

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100
 Purchasing Memo 0.00 CL 11/11/01 (10)
 Purchasing Issue P/O: 15317
 Make as per Dwg D3484
 Material release note is required

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
-----	--	------	--	--	--	--	--	--	--

110
 Packaging Memo 0.00 11/12/02 (10)
 Packaging

115	Weld per dwg A/R Aluminum rod Batch:	0.00							
-----	--------------------------------------	------	--	--	--	--	--	--	--

115
 Large Fab Memo 0.00
 Large Fab ***touch up weld if necessary***

[Handwritten signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
130 *130* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00							
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							

Handwritten notes: 11.12.05, 10, 11-12-5.

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	QC3- Inspect Part Finish	0.00							
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150

QC

Memo

Quality Control

160

160

Small Fab

Memo

Small Fab

1-Install Nut Plates as per Dwg D3484

0.00

0.00

0.00

0.00

170

QC5- Inspect part completeness to step on W/O

170

QC

Memo

Quality Control

8/11/12/06

10x Ø M-11/12/05

E 8/11/12/06 10

710

47

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11/12/11 JF
mf 11-12-07

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, October 31, 2011 3:38:24 PM

Page 1

Work Order ID: 75827

Parent Item: D3484-041

Parent Item Name: Tail Light Fairing Assembly, LH

Start Date: 11/1/2011

Required Date: 11/22/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-04-11 JLM
IPP Rev:B 08-01-24 chg rivet to CR1122-3-025 DD verf:EC IPP Rev:C 11.03.07 added weld touch up DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3484-041P Tail light Fairing		Purchased	No			110	Each	0.0000	1	10		11/12/12	(10)
MS21069-04 ANCHOR NUT		Purchased	No			160	Each	46.0000	2	20		11/12/06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST302		46							
				116823		46							
CR1122-3-02.5 RIVET		Purchased	No			160	Each	100.0000	4	40		11/12/06	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST336		100							
				118677		100							

Handwritten notes and signatures:

- 11/12/12 (10)
- 11/12/06
- M119546 (20x)
- 11/12/06
- 22
- M118462 (18x)

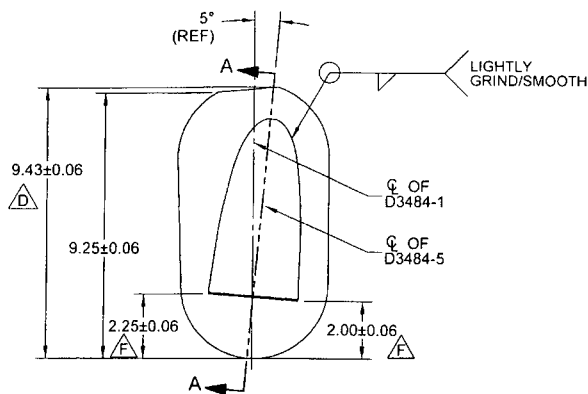
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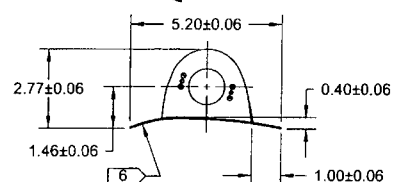
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NOTE: Date & initial all entries



QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
	1	D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT

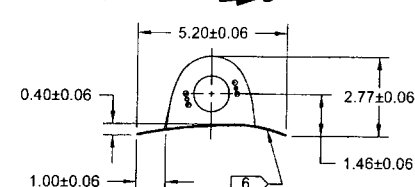
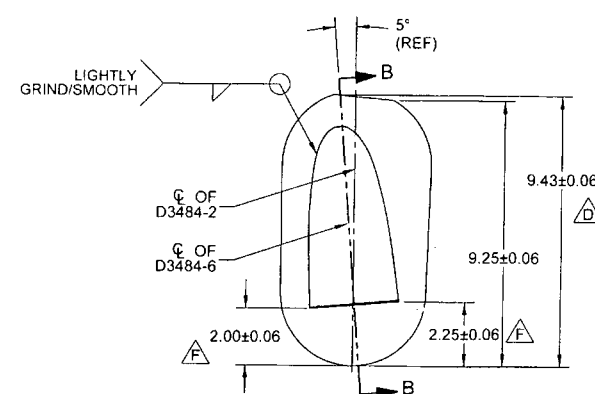


INSTALL MS21069-04
ANCHOR NUT
(2 PLACES)

SECTION A-A

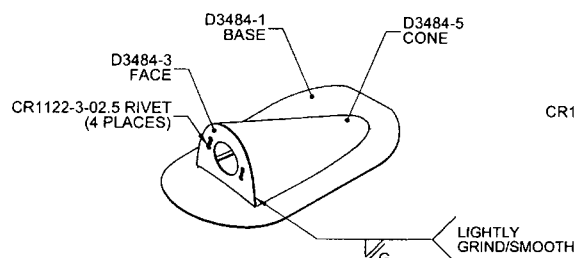
INSTALL MS21069-04
ANCHOR NUT
(2 PLACES)

SECTION B-B

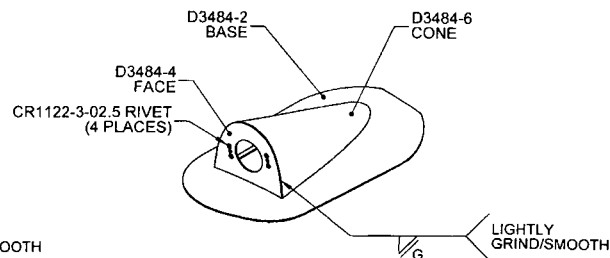


D3484-041 TAIL LIGHT FAIRING

D3484-042 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW



D3484-042 ISOMETRIC VIEW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) WELDING: PER DART QSI 004
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
- 7) WEIGHT: 0.30 lbs

F	UPDATE MATERIAL SPEC. ADD 6061-0, ZN A7-2, A7-3, B3-4, UPDATE DIMENSIONS ZN C1-1, C2-1, C7-1, C8-1 UPDATE WELDING NOTE ZN A3-1, A6-1		09.03.31
E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY. CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.31		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3484** REV. F
SHEET 1 OF 4
TITLE **TAIL LIGHT FAIRING** SCALE 1:4

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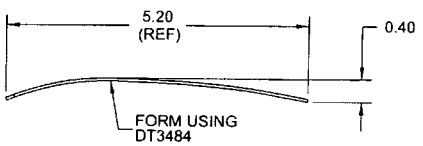
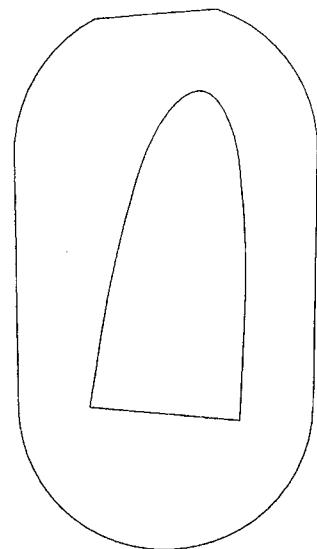
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

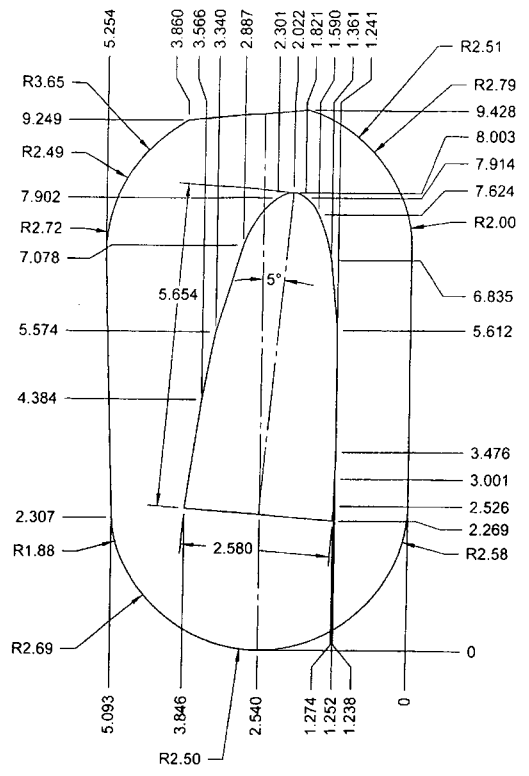
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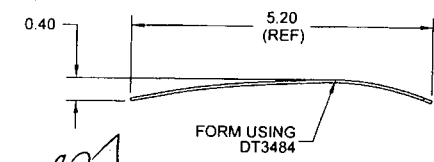
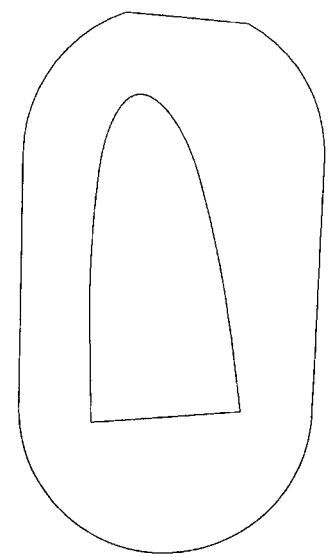


D3484-1 BASE
(MAKE FROM D3484-1F)

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.16 lbs



D3484-1F BASE FLAT PATTERN



D3484-2 BASE
(MAKE FROM D3484-1F)

RELEASED
27/02/24

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3484	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:2
DATE	09.03.31	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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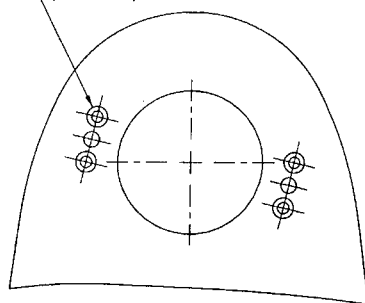
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

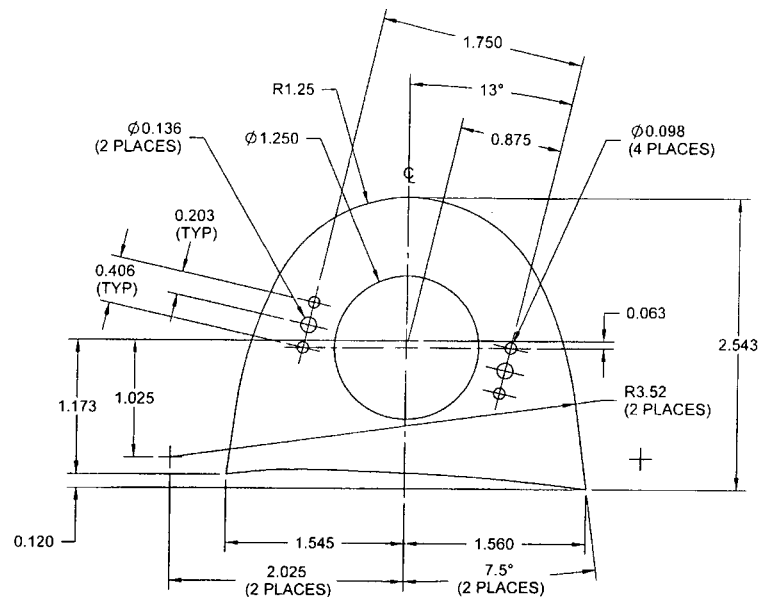
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NOTE: Date & initial all entries

C'SINK
Ø 0.181 X 100°
(4 PLACES)

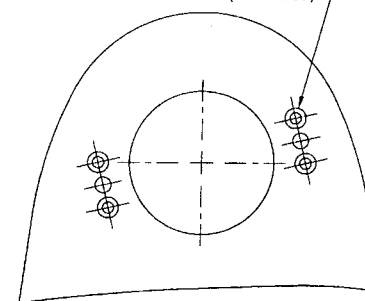


D3484-3 FACE
(MAKE FROM D3484-3F)



D3484-3F FLAT PATTERN TAIL LIGHT FAIRING

C'SINK
Ø 0.181 X 100°
(4 PLACES)



D3484-4 FACE
(MAKE FROM D3484-3F)

NOTES:

- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3484	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:
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09/07/24/11

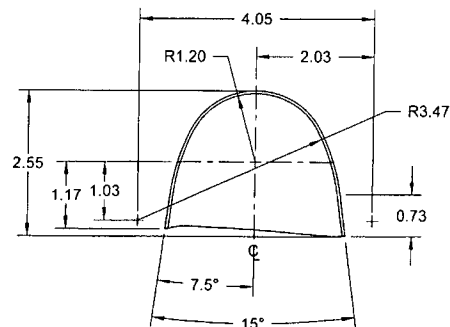
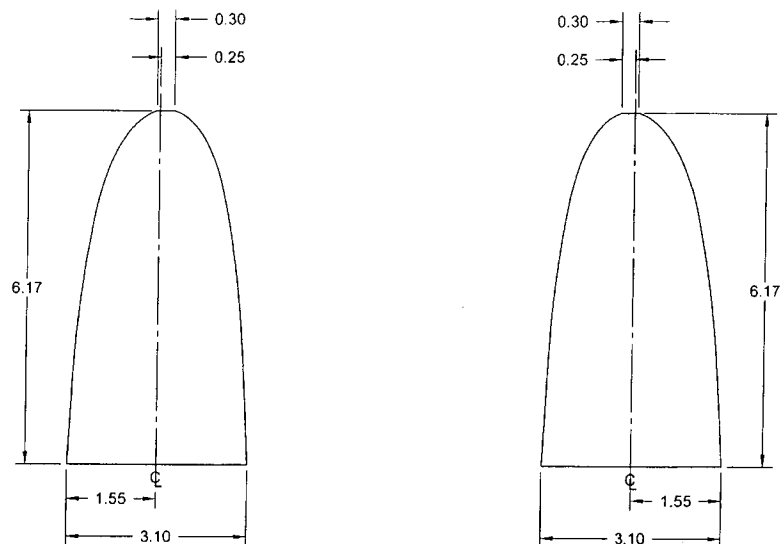
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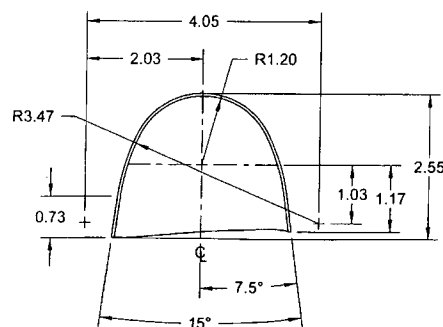
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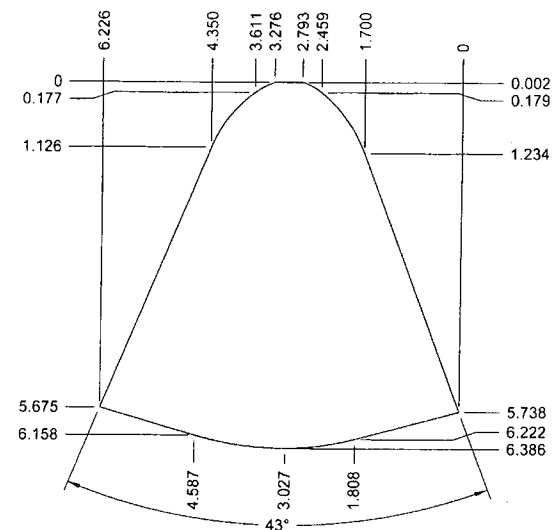
NOTE: Date & initial all entries



D3484-5 CONE
(MAKE FROM D3484-5F)



D3484-6 CONE
(MAKE FROM D3484-5F)



D3484-5F CONE FLAT PATTERN

- NOTES:**
- 1) MATERIAL: 6061-O ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.11 lbs

RELEASED
09/04/24

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3484	SHEET 4 OF 4
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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO15317**

Purchase Order Date 11/01/11

PO Print Date 11/01/11

Page Number 1 of 1

Order From :

VC-GF1001

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

Contact Name

Vendor Phone

514 630 4877

Vendor Fax

514 630 4849

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED
-\$

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3484-041P	Tail light Fairing	11/22/11 Yes	10.00 Each	FedEx Priority F	\$280.0000	\$2,800.00
		Special Inst: AS PER DWG D3484 REV. F B75827 FORMED & WELD AS PER QSI 005 CHEMICAL CONVERSION, NUTPLATE AND POWDER COAT TO BE DONE AT DART					
2	D3484-042P	Tail Light Fairing	11/22/11 Yes	10.00 Each	FedEx Priority F	\$280.0000	\$2,800.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Special Inst: AS PER DWG D3484 REV. F
B75828
FORMED & WELD AS PER QSI 005
CHEMICAL CONVERSION, NUTPLATE
AND POWDER COAT
TO BE DONE AT DART

PO Total:

\$5,600.00

Change Nbr: 3

Change Date: 11/01/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE				N° DE BON DE LIVRAISON / SHIPPING MEMO NO.	PAGE
JR - DY.	MO. - MO.	AN. - YR.			
01	12	11		0475299	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT / CUSTOMER CODE		N° DE CONTRAT / JOB NO.	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO.	EXPÉDIÉ PAR / SHIP VIA
DART		GFI-0299	0239349	PO15317
QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO.			DESCRIPTION
10	D3484041P			TAIL LIGHT FAIRING CERTIFICATE OF CONFORMANCE REQ

MFG. JOB# J0239349-001 QTY 10 pcs.

EXPÉDITEUR / SHIPPER

N° DE BON DE LIVRAISON / SHIPPING MEMO NO.



REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 6 JOURS DE LA RÉCEPTION

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	<u>5</u>	OUR JOB NO	<u>J0239349</u>	SHIPPING MEMO	<u>0475299</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>--</u>	<u>10 PCS</u>	<u>PO15317</u>	<u>D3484041P</u>	<u>F</u>	<u>TAIL LIGHT FAIRING</u>	<u>F</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>AL 6061-T0 (AMS-QQ-A-250/11)</u>		<u>TW METALS / KAISER ALUMINUM</u>		<u>534454A4</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>N/A</u>
2	<u>REF. GFI MANUFACTURING JOB NUMBER J0239349-001 (10 PCS)</u>		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 01 DECEMBER 2011

G.F.I. Q.C. REP. Carsten Harld





PACKING SLIP

ORDER NO.: 70461145 FROM: ATLA PAGE 1

CUST NUMBER: 1203148 NET WGT: 68.660 REQ. DATE: 11/18/11 CONFIRMED
SOLD TO: SHIP TO:
GFI INC GFI INC
180 AVE. LABROSSE 180 AVE LABROSSE
POINTE CLAIRE QC PIONTE CLAIR QC
CANADA CN H9R 1A1 CANADA CN H9R 1A1

SALESPERSON: DEANNA PIMM DISTRICT: ATLANTA
TERMS: 1% 10 NET 30 VIA: ROADWAY EXPRES
F.O.B.: SHIPPING POINT FREIGHT: COLLECT
CUST ORD NO.: 0079522 RELEASE NO.:
RECEIVING PHONE: 514 630-4877
WIDTH LENGTH

0001 76409 60610 ALM SHT STENCILLED .0500 48 144
QTY: 2.000 EA WT: 68.660 PC: 2 SHP: 68.660 LB

PART#: AS05148144PM

** 1 TEST REPORTS REQUIRED **

** 1 CERTS REQUIRED **

ECCN: EAR99 Export License: NLR Expiration Date: 0/00/00
PO:49245464 HT:534454A4 PC: 2 SLB/CL:KAISER* 34.33# EA*
MLT:UNITED STATES MFG:UNITED STATES

SHIP VIA EMERY DEFERED ACCT# 543483804 OR YELLOW COLLECT
CLEAR CUSTOMS THRU CONSIGNEE'S BROKER: DHL GLOBAL FORWARDING

PAGE TWO

next page
5



PACKING SLIP

ORDER NO.: 70461145 FROM: ATLA PAGE 2

CUST NUMBER: 1203148 NET WGT: 68.660 REQ.DATE: 11/18/11 CONFIRMED
SOLD TO: SHIP TO:
GFI INC GFI INC
180 AVE. LABROSSE 180 AVE LABROSSE
POINTE CLAIRE QC PIONTE CLAIR QC
CANADA CN H9R 1A1 CANADA CN H9R 1A1

SALESPERSON: DEANNA PIMM DISTRICT: ATLANTA
TERMS: 1% 10 NET 30 175 TUBEWAY
F.O.B.: SHIPPING POINT FOREST PARK GA 30297
CUST ORD NO.: 0079522
VIA: ROADWAY EXPRES
FREIGHT: COLLECT
RELEASE NO.:
RECEIVING PHONE: 514 630-4877

"TW Metals MSDS data is available on our web site at www.twmetals.com. MSDS data can be found under the Technical Resources Tab, Product Statistics & Data and the TW Metals MSDS's heading. If you do not have web site access you may telephone 610-458-1300 and we will mail or fax a copy of our current MSDS data to your location."

"CERTIFICATE OF CONFORMANCE"

"TW Metals certifies that the material supplied on this purchase order and contained in the heat/lot number referenced above has been manufactured, inspected, and tested in accordance with the material specification. These records are on file at TW Metals. Packaging material for shipments to Europe and China consists of manufactured wood products and complies with the European emergency measures for coniferous non-manufactured wood packing material"

Electronically Generated Certificate-Valid without signature Date: 11/16/11

These commodities have been exported from the United States in accordance with the U.S. export control laws, export administrations regulations. Diversion contrary to U.S. law prohibited.

THANK YOU FOR THIS ORDER

TERMS AND CONDITIONS APPLICABLE TO THE SALE OF THESE PRODUCTS ARE SET FORTH ON THE REVERSE SIDE FOR YOUR CAREFUL REVIEW.



PACKING SLIP

ORDER NO.: 70461145 FROM: ATLA PAGE 2

CUST NUMBER: 1203148 NET WGT: 68.660 REQ.DATE: 11/18/11 CONFIRMED
SOLD TO: SHIP TO:
GFI INC GFI INC
180 AVE. LABROSSE 180 AVE LABROSSE
POINTE CLAIRE QC PIONTE CLAIR QC
CANADA CN H9R 1A1 CANADA CN H9R 1A1

SALESPERSON: DEANNA PIMM DISTRICT: ATLANTA
TERMS: 1% 10 NET 30 175 TUBEWAY
F.O.B.: SHIPPING POINT FOREST PARK GA 30297
CUST ORD NO.: 0079522
VIA: ROADWAY EXPRES
FREIGHT: COLLECT
RELEASE NO.:
RECEIVING PHONE: 514 630-4877

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SHIP TO:
TW METALS
1200 BLAKE DRIVE
WICHITA, KS 67219

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4214878

SOLD TO:
TW METALS INC
THE ARBORETUM
760 CONSTITUTION DRIVE
EXTON, PA 19341

CUSTOMER PO NUMBER: M49245464		WORK PACKAGE:	CUSTOMER PART NUMBER: 76409		SHIP RUN/LOAD: 101963/6	GOVT CONTRACT NUMBER:
KAISER ORDER NO: 1108985	LINE ITEM: 1	SHIP DATE: 11-JAN-2011	ALLOY: 6061	CLAD: BARE	TEMPER: O	PRODUCT DESCRIPTION: HT Flat Sheet
WEIGHT SHIPPED: 8942 LB	QUANTITY: 261 PCS EST.	B/L NUMBER: 2030402	GAUGE: 0.0500 IN		DIAMETER/WIDTH: 48.000 IN	LENGTH: 144.000 IN

Certified Specifications

AMS 4025/RevL
CMMP 025/RevT

ASTM B 209/Rev07

CMMP 019/RevD

Test Code: 1925

Test Results

Lot: 534454A4 Cast 806

Drop 75

Ingot 1

(ASTM E8/B557)
(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	O	LT / 2 (Min:Max)	19.2 : 19.2 (132 : 132)	7.3 : 7.4 (50 : 51)	27.8 : 28.5
	T42	LT / 2 (Min:Max)	36.5 : 37.7 (252 : 260)	17.4 : 17.8 (120 : 123)	23.1 : 23.9
	T82	LT / 2 (Min:Max)	50.1 : 51.1 (345 : 352)	41.7 : 43.8 (288 : 302)	13.1 : 13.6

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.73	0.6	0.32	0.08	1.0	0.19	0.12	0.02	0.01	0.00	TOT 0.05

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
6061 MIN	0.40	0.0	0.15	0.00	0.8	0.04	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

TW METALS	
T E S T	R E P O R T S
JAN 14 2011	
ACCEPTED BY <i>JK</i>	

SHIP TO:

TW METALS
1200 BLAKE DRIVE
WICHITA, KS 67219

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

SOLD TO:

TW METALS INC
THE ARBORETUM
760 CONSTITUTION DRIVE
EXTON, PA 19341

CERTIFIED TEST REPORT

Serial Number
4214878

CUSTOMER PO NUMBER: M49245464		WORK PACKAGE:	CUSTOMER PART NUMBER: 76409			SHIP RUN/LOAD: 101963/6		GOV'T CONTRACT NUMBER:	
KAISER ORDER NO: 1108985	LINE ITEM: 1	SHIP DATE: 11-JAN-2011		ALLOY: 6061	CLAD: BARE	TEMPER: O	PRODUCT DESCRIPTION: HT Flat Sheet		
WEIGHT SHIPPED: 8942 LB		QUANTITY: 261 PCS EST.		B/L NUMBER: 2030402		GAUGE: 0.0500 IN		DIAMETER/WIDTH: 48.000 IN	LENGTH: 144.000 IN

Certified Specifications

AMS 4025/RevL
CMMP 025/RevT

ASTM B 209/Rev07

CMMP 019/RevD

Test Code: 1925

Test Results

Lot: 534454A4 Cast 806

Drop 75

Ingot 1

(ASTM E8/B557)

(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	O	LT / 2 (Min:Max)	19.2 : 19.2 (132 : 132)	7.3 : 7.4 (50 : 51)	27.8 : 28.5
	T42	LT / 2 (Min:Max)	36.5 : 37.7 (252 : 260)	17.4 : 17.8 (120 : 123)	23.1 : 23.9
	T62	LT / 2 (Min:Max)	50.1 : 51.1 (345 : 352)	41.7 : 43.8 (288 : 302)	13.1 : 13.6

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.73	0.6	0.32	0.08	1.0	0.19	0.12	0.02	0.01	0.00	TOT 0.05

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
6061 Min	0.40	0.0	0.15	0.00	0.8	0.04	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

TW METALS	
T E S T	R E P O R T S
JAN 14 2011	
ACCEPTED BY <i>JK</i>	